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IS 4108 (1984): Snap Fasteners for Dresses [PGD 14:
Consumer Products and Allied Equipments]



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“ज्ञान एक ऐसा खजाना है जो कभी चुराया नहीं जा सकता है”

Bhartrhari—Nitiśatakam

“Knowledge is such a treasure which cannot be stolen”

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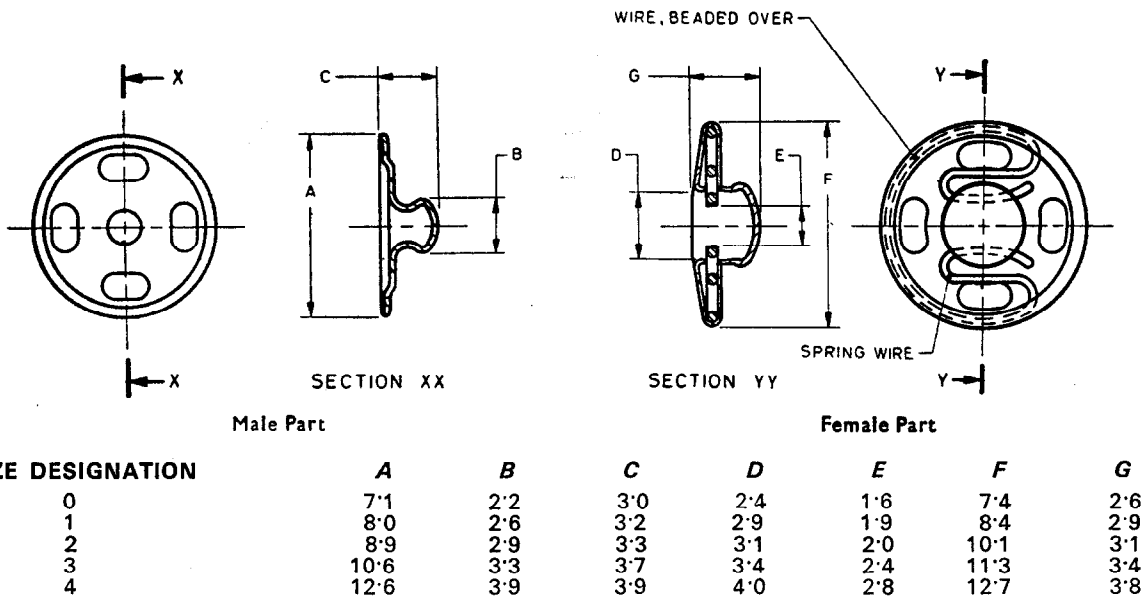


Indian Standard

SPECIFICATION FOR
SNAP FASTENERS FOR DRESSES

(First Revision)

1. **Scope** — Specifies the requirements of snap fasteners used in dresses.
2. **Shape and Dimensions** — As shown in Fig. 1.



All dimensions in millimetres.
FIG. 1 SNAP FASTENER FOR DRESSES

3. **Materials** — Different components of the snap fastener shall be made of the materials given in Table 1 and shall satisfy the requirements mentioned therein :

TABLE 1 MATERIAL REQUIREMENTS FOR SNAP FASTENERS				
Components	Material	Conforming to	Thickness <i>Min</i> (mm)	Plating
(1)	(2)	(3)	(4)	(5)
Male and female part	Brass	IS : 410-1977*	0.180	Nickel
Spring wire for female part	Phosphor-bronze	IS : 7608-1975†	0.450	
*Specification for cold rolled brass sheet, strip and foil (<i>third revision</i>).				
†Specification for phosphor-bronze wires (for general engineering purposes).				

4. **Manufacture and Workmanship**

- 4.1 The snap fastener shall be made in two parts, that is, male and female.
- 4.1.1 The male and female parts shall be stamped from the sheet, pressed and drawn out to the required shape and size.
- 4.1.2 A spring wire shall be affixed in the loop form as given in Fig. 1.
- 4.2 The snap fasteners shall be free from pits, cracks, wrinkles, dents and other surface defects. There shall be no sharp edges.

5. Marking

5.1 Each card on which the snap fasteners are mounted shall be clearly and indelibly marked with the manufacturer's name, initials or trade-mark.

5.2 *ISI Certification Marking* — Details available with the Indian Standards Institution.

6. Packing

6.1 Thirty-six pieces of snap fasteners shall be pressed together on a punched card, 8 such cards shall be packed in a cardboard box.

7. Tests

7.1 *Performance Test* — The fastener shall not show sign of damage or looseness after opening and closing in quick succession for 500 times and in further operations. It shall work neither too loose nor shall it require great force to disengage.

7.2 *Strength of Push Fit* — The female part shall be gripped in a suitable fixture so that its front part projects outside the jaws. The male part shall disengage from the female part by a gradually applied perpendicular load as given below for different size designations.

Size Designation	Disengagement Load
0	400 \pm 50 g
1	600 \pm 100 g
2	800 \pm 100 g
3	1 200 \pm 200 g
4	2 000 \pm 200 g

7.3 *Resistance to Lateral Pull* — The female part shall be gripped in a suitable fixture so that its front part projects outside the jaws. The male part shall be engaged into the female part and then a lateral load equivalent to 1.5 times the nominal disengagement load as shown in 7.2 is applied. The male part shall not disengage.

7.4 *Tests for Corrosion Resistance* — Dip the fasteners in a solution of mineral spirit to remove the surface film or grease and wipe dry. Place the specimens in a boiling 10 percent aqueous solution of sodium chloride for 15 minutes. Remove them from the solution and immediately place them in a similar solution at room temperature for 24 hours. Allow to dry at room temperature without wiping. Rinse the specimen in luke warm water. Allow them to dry and examine the specimens for signs of corrosion. There shall not be any sign of corrosion.

8. Sampling

8.1 *Lot* — All the cardboard boxes of snap fasteners of the same size for dresses produced under similar conditions from the same raw materials shall be grouped together to constitute a lot.

8.2 *Selection of Samples* — The number of snap fasteners to be selected from the lot shall depend upon the size of the lot and shall be in accordance with col 1, 2 and 3 of Table 2. More or less equal number of snap fasteners shall be chosen from the boxes to constitute a sample of size as given in col 3 of Table 2.

TABLE 2 SAMPLE SIZE AND CRITERIA FOR CONFORMITY

Lot Size (No. of Boxes)	Sample Size (No. of Boxes)	For Shape and Dimensions, Manufacture and Workmanship		For Performance Test Strength of Push Fit, Resistance to Lateral Pull and Tests for Corrosion Resistance	
		Sub-Sample Size (No. of Snap Fasteners)	Acceptance Number	Sub-sample Size (No. of Snap Fasteners)	Acceptance Number
(1)	(2)	(3)	(4)	(5)	(6)
Up to 25	3	8	1	3	0
26 „ 50	5	13	1	5	0
51 „ 100	5	20	2	5	0
101 „ 150	8	32	3	8	1
151 „ 300	13	50	5	13	1
301 and above	20	80	7	13	1

8.2.1 These snap fasteners shall be selected at random from a lot. In order to ensure the randomness of selection, procedures given in IS : 4905-1968 'Methods for random sampling' shall be followed.

8.3 *Number of Tests and Criteria for Conformity*

8.3.1 The number of snap fasteners selected at random in accordance with col 3 of Table 2 shall be tested for shape and dimensions (2). The lot shall be considered as conforming to this test if the number of defectives found in the sample is less than or equal to the corresponding permissible number of defectives as given in col 4 of Table 2.

8.3.2 The lot having been found conforming to **8.3.1** shall be tested for performance test (7.1), strength of push fit (7.2), resistance to lateral pull (7.3) and corrosion resistance (7.4). For this purpose, a sub-sample of size given in col 5 of Table 2 shall be taken from snap fasteners as selected for **8.2**. The lot shall be considered as conforming to the requirements of the above mentioned tests if all the snap fasteners in the sample pass.

8.3.3 The lot shall be considered as conforming to the standard if **8.3.1** and **8.3.2** are satisfied.